



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3371-3
Job Sheet 203841



Part No: D3371-3

Job Qty: 8 pcs

Part Name: Pedal Lock Cover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/19

Job Tracking No:

Due Date: 1/30/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV B IPP A 05.01.18 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs		1/30/20	0.00	0.13	Bandsaw - 1		ALA 20/03/09
110	HAAS 4 Axis - B4B	8 pcs		1/30/20	0.17	12.70	HAAS - 1 - B4B		ALA 20/03/09
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	8 pcs		1/30/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



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CANADA
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Container No: S261567



Part: D3371-3

Job No: 203841

Serial No/Batch: S261567

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/08/20

130	QC 8	8 pcs	1/30/20	0.00	0.00	QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	A. 20-04-28
140	Handfinish - 1-1 Chemical-B4B	8 pcs	1/30/20	0.00	0.45	QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						Handfinish - 1 - 1 - B4B	BEB 20-05-12
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 -	

				B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
145	Powdercoat - 6 Fire Red - B4B	8 pcs	1/30/20	0.00 1.05	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
150	QC 3	8 pcs	1/30/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
160	Packaging 3-1 - Stock - B4B	8 pcs	1/30/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B

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				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	8 pcs	1/30/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	8-8 MAY 20 2020

Part Op 100 - Cut blank: 2.00" x 2.25" x 7.370" long
 Descriptions: 110 - (HAAS CNC Vertical Machine), 1-Machine D3371-3 as per Folio FA486 and Dwg D3371 3-Finish 8-32 thread by hand Identify as D3371-3
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 145 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3), ***cover inside holes prior painting***
 150 - (QC3- Inspect Part Finish)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6S2.000X02.250	6061-T6 SHEET2.00 X 2.25	5 ft (.625 ea)	100-Bandsaw - 1	S234877 S250479

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6S2.000X02.250	5	1	0

Part Specifications	
Specifications could not be found.	

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DART AEROSPACE LTD		Work Order: 203841
Description: Pedal Lock Cover		Part Number: D3371-3
Inspection Dwg: D3371 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.450	+/-0.005	1.448			VERV	B/8017739
7°	+/-0.5°	7°			CNC-17	A-G
0.104	+/-0.010	.106			VERV	B/8017739
0.305	+/-0.010	.303			"	
1.650	+/-0.010	1.648			"	
1.30	+/-0.030	1.295			"	
Ø1.000	+/-0.010	1.001			"	
45°	+/-0.5°	45.1°			CNC-17	A-G
Ø1.300	+/-0.010	1.300			VERV	B/8017739
0.500	+/-0.010	.501			"	
60°	+/-0.5°	60.2°			CNC 17	AG
2.25	+/-0.030	2.250			VERV	B/8017739
1.650	+/-0.010	1.649			"	
3.950	+/-0.010	3.952			"	
1.330	+/-0.005	1.330			"	
7.19	+/-0.030	7.19			"	
4.500	+/-0.010	4.496			H-G	3/006
0.635	+0.010/-0.000	.635			VERV	B/8017739
1.125	+/-0.010	1.125			"	
0.750	+/-0.010	.750			"	
Ø0.750	+0.010/-0.000	.750			"	
3.625	+/-0.010	3.620			H-G	3/006
Ø1.200	+/-0.010	1.200			VERV	B/8017739
0.750 deep	+/-0.010	.749			"	
0.500	+/-0.010	.495			"	
2.00	+/-0.030	1.999			"	
1.000	+/-0.010	1.000			"	
0.375	+/-0.010	.374			"	
Ø0.185	+0.005/-0.000	.1865			GP	
0.400 deep	+/-0.010	.410			VERV	B/8017739

Measured by: ALA	Audited by: Aa	Prototype Approval:	N/A
Date: 20/03/06	Date: 20-04-28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM	

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QSI042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			